

Date: Tuesday, 7/18/2006 2:40:26 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number : 27940A	
Estimate Number : 10163	
P.O. Number : <i>N/A</i>	Part Number : D206642241
This Issue : 7/18/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2650 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : E
Previous Run : 27939A	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 8/25/2006 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:M 04.12.02 Revised procedural steps KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PRP D206-642-241 CHG003

KS 06.07.27 ①

2.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	<i>B27831</i>

DP 6-8-14

3.0	D32861	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3286-1	Doubler	<i>B21599</i>

DP 6-8-16

4.0	D2647	Cap
-----	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2647	Fwd Cap	<i>B24842</i>

BE 06-08-14

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

DP 6-8-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description:

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

DPG-8-14

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M18839/M100660 BE 06-08-14

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

DPG-8-14

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

DPG-8-15

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

DPG-8-16

15-C'sink GHW rivet holes as per Dwg D2650

DPG-8-16

6.0

QC6

DIMENSIONAL CHECK



PM 06-08-180



Comment: DIMENSIONAL CHECK

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE				
DATE	STEP	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Corrective Action				Verification Section C	Approval Design Mgr	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

Handwritten: 6-8-18

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: PM 06-8-18

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: BE 6-8-21

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

Handwritten: BE 6-8-21

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Handwritten: 06-06-22

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

52 CR3212-4-04

Rivet

Handwritten: m 101660 BE 06-08-23

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

13.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2654-3

Web

B28178 BE 06-08-23

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

BE 06-08-23

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: *06-08-23*

Time: *1:30*

Finish Date: *06-08-24*

Time: *3:00*

BE 06-08-24

Pick:

Qty Part Number

Description Batch

A/R Sikaflex-291

M101855

Sikaflex expire date:

07-02

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Pm 06-08-24

16.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

18 D2649

Crossbolt spacer

B25864 BE 06-08-28

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3286-3

Spacer

B24711 BE 06-08-29

NOTE: See H:\forms\Quality Assurance\approved forms\NCRWO revC

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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M18839 BE 06-08-28

2-Grind welds flush as per Dwg D2650. Pm' 06-08-29

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R SS Rod NONE USED BE 06-08-29

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Debur Pm' 06-08-29

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets M101938

Pm' 06-08-29 (2)

20.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets M14477

M19099

Pm' 06-08-29 (1)

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate B24203

Pm' 06-08-29 (1)

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Job Number: 27940A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Pm 06-08-29 (1)

23.0

QC59

WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

PD 06-08-30 (1)

24.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

A.M 06-09-05 (1)

25.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/09/05 (1)

26.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2648-3

Wearpad

B27169-2

27.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe

B27074

28.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B20917

DL 06/09/05 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 27940A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B15962

30.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B24417

31.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130 Inserts

M19393

or (see QSI 017)

X

32.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 AN960JD10L

Washer

M100233

33.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS27039-1-08

Screw

M19551

DL 06/09/05 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 27940A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2651-1 Plugs B27362

35.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2651-3 O-Rings B25866

36.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw M6874

37.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer M11151

DL 06/09/05 (1)

38.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 M101953

Sikaflex expire date: 10/06

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

DL ~~06/09/05~~ 06/09/05 (1)

W/O:		WORK ORDER CHANGES					
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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect for foreign objects as per QSI 024

40.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B28041

41.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M19551

X

42.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M100233

DL 06/09/05 (1)

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M101953

Sikaflex expire date: 10/06

DL 06/09/05 (1)

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: M101667

A.M

06-09-06

(1)

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

44.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

Job-09-13 (1)

45.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/09/19 (1)

Job Completion



U 06.09.19

W/O:		WORK ORDER CHANGES					
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DARTRELEASED
16 04 17

DESIGN <i>19</i>	DRAWN BY <i>19</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET


NOTES

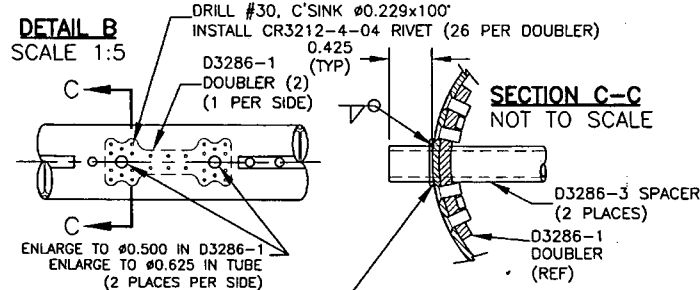
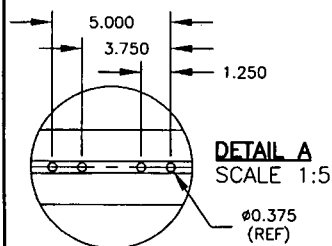
- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH:
-CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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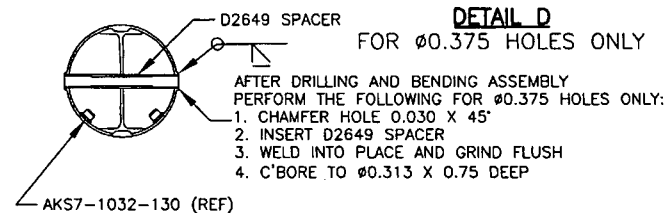
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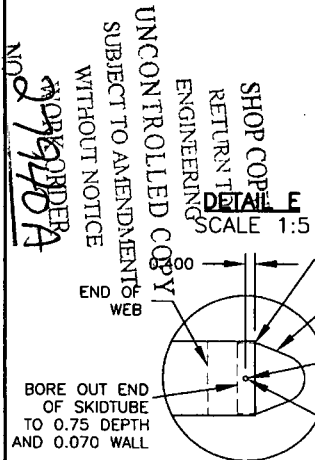


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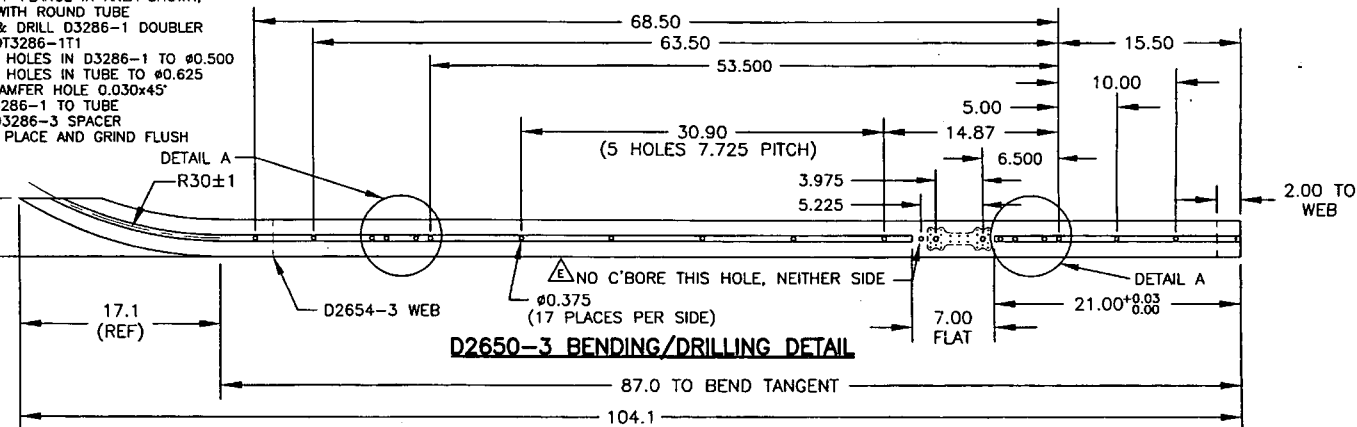


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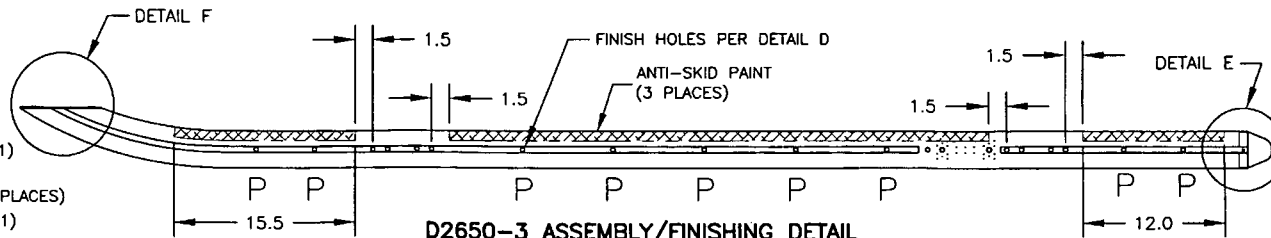


- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO 0.500
 4. ENLARGE HOLES IN TUBE TO 0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

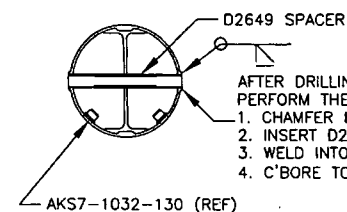
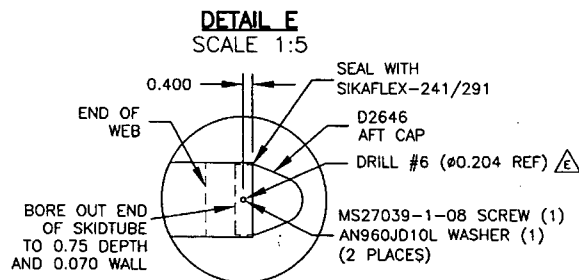
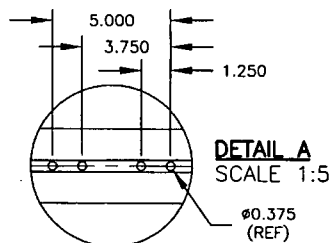


DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH
- CCR2645S3-3 RIVET (2 PLACES)
- MS27039-4-06 SCREW (1)
- AN960JD416 WASHER (1)
- CR3212-4-03 RIVET (2 PLACES)
- D2680-041 NUTPLATE (1)
- D2647 CAP (1)
- 1/16
- 1.0
- REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.
- ORIENTATION OF D2680-041



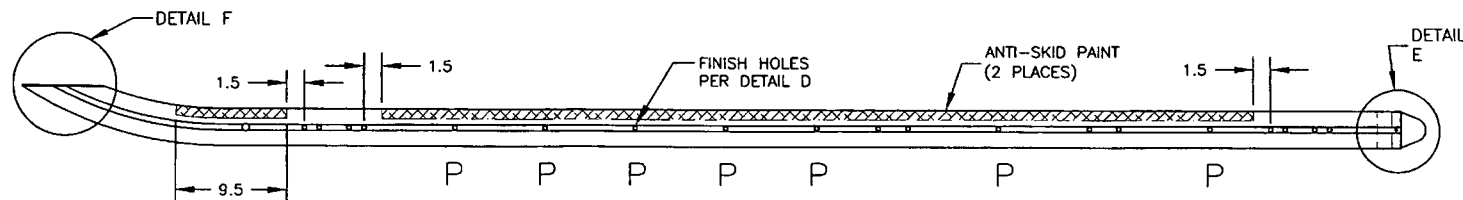
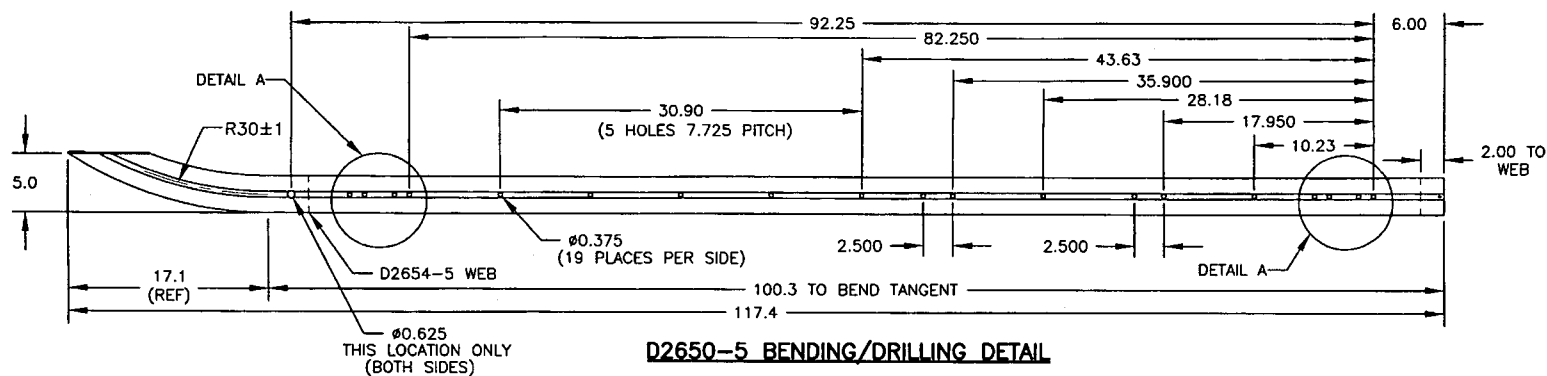
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- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313 X 0.75 DEEP

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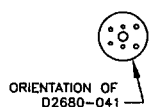
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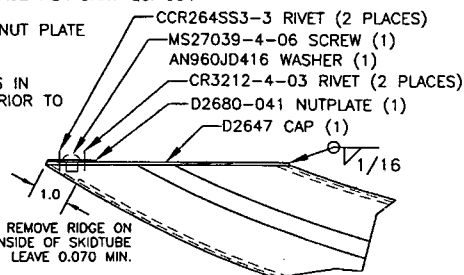
DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.



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